

What we claim is:

1. A method for manufacturing at least two types of trim level pieces comprising the steps of:

a. preparing a mold having a first piece including a first surface, a second piece including a second surface, and at least one injection port located in the second piece wherein the injection port has an outlet associated with the second surface wherein the mold first piece and second piece unite to form an internal cavity; and

b. preparing at least two different trim level pieces using the mold wherein the trim level pieces are selected from;

i. a first trim level piece prepared by injecting a resin into the mold and thereafter removing the cured first level trim piece from the mold and painting at least one surface of the molded trim piece;

ii. a second trim level piece that is prepared by the further steps comprising:

preparing a preformed skin having a (decorated) first surface and a second surface wherein the preformed skin first surface has a shape complementary to the mold first surface;

placing the preformed skin into the mold such that the preformed skin first surface contacts the mold first surface;

closing the mold and injecting resin into the mold through the at least one injection port and into contact with the preformed piece second surface until the internal cavity is filled with resin to form a second trim level piece; and

removing the second trim level piece from the mold;

iii a third trim level trim piece that is prepared by the further steps comprising:

5 preparing a shaped metal piece from flat metal stock wherein the shaped metal piece has a first surface and a second surface and wherein the shaped metal piece first surface has a shape complementary to the shape of the mold first surface;

placing the shaped metal piece into the mold such that the metal sheet first surface is in contact with the mold first surface;

10 closing the mold and injecting resin into the mold through the at least one injection port until the mold cavity is "filled with resin" to form a third trim level piece; and

removing the third trim level piece from the mold; and

iv. a forth trim level piece that is prepared by the further steps comprising;

15 preparing a wooden trim piece having a first surface and a second surface wherein the wooden trim piece first surface has a shape that is complementary to the shape of the mold first surface;

placing the wooden trim piece into the mold such that the wooden trim piece first surface is in contact with the mold first surface;

20 closing the mold and injecting a resin into the mold through the at least one injection port and into contact with the wood trim piece second surface until

the mold cavity is filled with resin to form a forth trim level piece; and
removing the fourth trim level piece from the mold.

2. The method of claim 1 wherein each trim level piece has essentially the same thicknesses at identical locations on the piece.

5 3. The method of claim 1 wherein the method is used to manufacture at least three types of different trim level pieces.

4. The method of claim 1 wherein an adhesive material is applied to the second surface of the shaped metal piece of the third trim level piece before the shaped metal piece is placed in the mold.

10 5. The method of claim 4 wherein the adhesive material is applied to the second surface before the flat metal sheet is shaped.

6. The method of claim 1 wherein first surfaces of the preformed skin of the second trim level piece includes a decorated first surface.

15 7. The method of claim 1 wherein the preformed skin of the second trim level piece has a thickness of from about 0.008 to about 0.030 inches.

8. The method of claim 1 wherein the shaped metal piece of the third trim level piece has a thickness of from about 0.012 to about 0.018 inches.

9. The method of claim 1 wherein a glass filled resin is used to manufacture the third trim level piece.

20 10. The method of claim 9 wherein a glass filled thermoplastic is used to manufacture the third trim level piece.

11. The method of claim 1 wherein the preformed skin of the second trim level piece is a preformed piece further comprising a layer of cloth and a layer and a layer of plastic.

12. A decorative automobile trim piece comprising:

a formed metal sheet having decorated first surface and a second surface wherein the
5 metal sheet has a thickness of no greater than about 0.025 inches; and

a resin layer applied to the formed metal sheet second surface wherein the resin layer has a thickness of no greater than 2.5 mm.

13. The decorative automobile trim piece of claim 12 wherein the metal is aluminum.

14. The decorative automobile trim piece of claim 12 wherein the resin is glass filled
10 resin.

15. The decorative automobile trim piece of claim 14 wherein the resin is glass filled nylon resin.

16. The decorative automobile trim piece of claim 14 wherein the glass filled resin includes from about 10 to about 30 wt% of glass fibers.

15 17. The decorative automobile trim piece of claim 12 wherein an adhesive is located between the metal second surface and the resin.

18. A method for manufacturing at least two types of trim level pieces comprising the steps of:

a. preparing a mold having a first piece including a first surface, a second piece
20 including a second surface, and at least one injection port located in the second piece wherein the injection port has an outlet associated with the second surface wherein the mold first piece and

second piece unite to form an internal cavity; and

b. preparing at least two different trim level pieces using the mold wherein the trim level pieces are selected from;

i. a first trim level piece prepared by injecting a resin into the mold and thereafter removing the cured first level trim piece from the mold and painting at least one surface of the molded trim piece;

ii. a second trim level piece that is prepared by the further steps comprising:
preparing a preformed skin having a (decorated) first surface and a second surface wherein the preformed skin first surface has a shape complementary to the mold first surface;

placing the preformed skin into the mold such that the preformed skin first surface contacts the mold first surface;

closing the mold and injecting resin into the mold through the at least one injection port and into contact with the preformed piece second surface until the internal cavity is filled with resin to form a second trim level piece; and

removing the second trim level piece from the mold;

iii a third trim level trim piece that is prepared by the further steps comprising:

preparing a shaped metal piece from flat metal stock wherein the shaped metal piece has a first surface and a second surface and wherein the shaped metal piece first surface has a shape complementary to the shape of the mold first

surface;

placing the shaped metal piece into the mold such that the metal sheet first surface is in contact with the mold first surface;

closing the mold and injecting resin into the mold through the at least one injection port until the mold cavity is "filled with resin" to form a third trim level piece; and

removing the third trim level piece from the mold; and

iv. a forth trim level piece that is prepared by the further steps comprising;

preparing a wooden trim piece having a first surface and a second surface wherein the wooden trim piece first surface has a shape that is complementary to the shape of the mold first surface;

placing the wooden trim piece into the mold such that the wooden trim piece first surface is in contact with the mold first surface;

closing the mold and injecting a resin into the mold through the at least one injection port and into contact with the wood trim piece second surface until the mold cavity is filled with resin to form a forth trim level piece; and

removing the fourth trim level piece from the mold wherein at least one of the trim level pieces is a second or third trim level piece and wherein an insert selected from the preformed skin and the preshaped metal piece includes a through hole.

19. An automobile trim level piece prepared by the method of claim 18 wherein the trim level piece includes at least one resin feature.

20. A trim level piece comprising:

an insert having at least one through hole and further including a decorative surface,
and a backing;

a resin backing associated with the insert backing; and

5 at least one resin feature located on the insert decorative surface.

21. The trim level piece of claim 20 wherein the insert is a preformed skin, a
preformed metal.

22. The trim level piece of claim 20 wherein the insert is comprised of the
combination of a preformed skin layer and a preformed metal layer.

10 23. The trim level piece of claim 20 wherein the resin is selected from a colored resin,
a transparent resin, and an opaque resin.